

ABSTRACT OF THE DISCLOSURE

A steel cutting apparatus includes a cutting torch that is moved in an arcuate path for guiding the cutting torch so that a cutting flame of the cutting torch is always aimed at a bottom corner of the steel at the side where the cutting process begins. Molten steel and iron oxide flow through a kerf in the steel toward the bottom corner, and drop away from the billet for collection and disposal. Only a very small amount of slag adheres to the bottom corner of the billet when cutting is complete.